



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2572**Job Sheet 194401****Part No:** D2572**Job Qty:** 12 pcs**Part Name:** Saddle, Fwd, In**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 5/1/19**Job Tracking No:****Due Date:** 5/31/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:****Note:** DWG REV F IPP: I 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Machining - Issue SN	12 pcs	5/31/19		0.00	0.00	HAAS - 1		SBL 19/05/07
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
100	HAAS 4 Axis - B4B	12 pcs	5/31/19		0.00	19.35	HAAS - 1 - B4B		SBL 19/05/12
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
110	Conventional Mill - 1 - B4B	12 pcs	5/31/19		0.00	1.92	Conventional Mill - 1 - B4B		SBL 19/05/12
							Conventional Mill - 2 - B4B		
120	QC 2	12 pcs	5/31/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		



Dart Aerospace Ltd.
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CANADA
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Container No: S178807**Part:** D2572**Job No:** 194401**Serial No/Batch:** S178807**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 05/08/19

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					QC 2 - 50						
					QC 2 - 51						
					QC 2 - 52						
					QC 2 - 57	SBL 19/05/12					
					QC 2 - 62						
					QC 2 - 63						
					QC 2 - 8						
					QC 2 - 66						
					QC 2 - 64						
					QC 2 - 65						
					QC 2 - 5						
					QC 2 - 71						
					QC 8 - 12						
					QC 8 - 14	DR 19/05/13					
130 QC 8	12 pcs	5/31/19	0.00	0.00	QC 8 - 17						
					QC 8 - 20						
					QC 8 - 25						
					QC 8 - 3						
					QC 8 - 32						
					QC 8 - 33						
					QC 8 - 35						
					QC 8 - 39						
					QC 8 - 4						
					QC 8 - 44						
					QC 8 - 45						
					QC 8 - 49						
					QC 8 - 58						
					QC 8 - 8						
					QC 8 - 9						
					QC 8 - 68						
					QC 8 - 67						
					QC 8 - 1 (A)						
					QC 8 - 47						
					QC 8 - 40						
					QC 8 - 52						
					QC 8 - 23						
					140 Handfinish - 1-1 Chemical-B4B	12 pcs	5/31/19	0.00	0.49	Handfinish - 1 - 1 - B4B	
										Handfinish - 1 - 2 - B4B	
Handfinish - 1 - 3 - B4B											
Handfinish - 1 - 4 - B4B											
Handfinish - 1 - 5 - B4B											
Handfinish - 1 - 6 - B4B											
Handfinish - 1 - 7 - B4B											
Handfinish - 1 - 8 - B4B											
Handfinish - 1 - 9 - B4B											
Handfinish - 1 - 10 - B4B	DR 19/05/14										
Handfinish - 1 - 11 - B4B											
Handfinish - 1 - 12 - B4B											
Handfinish - 1 - 13 - B4B											
Handfinish - 1 - 14 - B4B											
Handfinish - 1 - 15 - B4B											
Handfinish - 1 - 16 - B4B											
Handfinish - 1 - 17 -											
										Plex 5/1/19 1:49 PM Dart.lajeunesse.mari	

				B4B		
				Handfinish - 1 - 18 - B4B		
				Handfinish - 1 - 19 - B4B		
				Handfinish - 1 - 20 - B4B		
				Handfinish - 1 - 21 - B4B		
				Handfinish - 1 - 22 - B4B		
150	Powdercoat - 1 White Gl(A)- B4B	12 pcs	5/31/19	0.00	0.46	Powdercoat - 1 - B4B
				Powdercoat - 2 - B4B		
				Powdercoat - 3 - B4B		
				Powdercoat - 4 - B4B		
160	QC 3	12 pcs	5/31/19	0.00	0.00	QC 3 - 10
				QC 3 - 13		
				QC 3 - 15		
				QC 3 - 17		
				QC 3 - 18		
				QC 3 - 2		
				QC 3 - 28		
				QC 3 - 3		
				QC 3 - 30		
				QC 3 - 34		
				QC 3 - 36		
				QC 3 - 41		
				QC 3 - 51		
				QC 3 - 58		
				QC 3 - 59		
				QC 3 - 68		
				QC 3 - 9		
				QC 3 - 40		
				QC 3 - 19		
170	Packaging 3-1 - Stock - B4B	12 pcs	5/31/19	0.00	0.00	Packaging 3 - 1 - B4B
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		

BL 19-5-14

MIST 749.

START: 4:15 OUT: 300° F MIST: 4:45.

DAS
MAY 15 2019 40
9-89

					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180	QC 21 - SA	12 pcs	5/31/19	0.00 0.00	QC 21 - SA - 21	00-8
					QC 21 - SA - 70	12 MAY 15 2019
					QC 21 - SA - 53	00-8

Part Op 100 - (HAAS CNC vertical machine #1) Program Batch No. 5178807 Double check by: SL 1-Machine Step No 1
 Descriptions: per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and insp
 110 - (Manufacture as per dwg) Machine keyway as per dwg D2571 & D2572
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ FINISH TIME: _____
 160 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-005	Saddle Billet	12 pcs (1 ea)	100-HAAS 4 Axis - B4B	4x 5166590 8x 5166690

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis - B4B	D6101-005	12	54	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Fwd Inboard	0.438Inches + 0.005 - 0.000	0.443 0.438		
2	Saddle, Fwd Inboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
3	Saddle, Fwd Inboard	3.495Inches + 0.010 - 0.000	3.505 3.495		
4	Saddle, Fwd Inboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
5	Saddle, Fwd Inboard	7.990Inches + 0.020 - 0.000	8.010 7.990		
6	Saddle, Fwd Inboard	0.490Inches + 0.020 - 0.000	0.510 0.490		
7	Saddle, Fwd Inboard	0.257Inches + 0.005 - 0.000	0.262 0.257		
8	Saddle, Fwd Inboard	0.375Inches + 0.005 - 0.000	0.380 0.375		
9	Saddle, Fwd Inboard	0.490Inches + 0.020 - 0.000	0.510 0.490		
10	Saddle, Fwd Inboard	1.174Inches + 0.010 - 0.000	1.184 1.174		
11	Saddle, Fwd Inboard	0.558Inches + 0.020 - 0.000	0.578 0.558		
12	Saddle, Fwd Inboard	1.174Inches + 0.010 - 0.000	1.184 1.174		
13	Saddle, Fwd Inboard	1.490Inches + 0.010 - 0.000	1.500 1.490		
14	Saddle, Fwd Inboard	2.495Inches + 0.010 - 0.000	2.505 2.495		

15	Saddle, Fwd Inboard	3.869Inches	+ 0.010 - 0.000	3.879 3.869
16	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
17	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
18	Saddle, Fwd Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
19	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
20	Saddle, Fwd Inboard	0.178Inches	+ 0.020 - 0.000	0.198 0.178
21	Saddle, Fwd Inboard	2.940Inches	+ 0.040 - 0.000	2.980 2.940
22	Saddle, Fwd Inboard	0.230Inches	+ 0.020 - 0.000	0.250 0.230
23	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
24	Saddle, Fwd Inboard	0.307Inches	+ 0.005 - 0.000	0.312 0.307
25	Saddle, Fwd Inboard	0.760Inches	+ 0.005 - 0.000	0.765 0.760
26	Saddle, Fwd Inboard	0.352Inches	+ 0.020 - 0.000	0.372 0.352
27	Saddle, Fwd Inboard	0.470Inches	+ 0.060 - 0.000	0.530 0.470
28	Saddle, Fwd Inboard	0.615Inches	+ 0.020 - 0.000	0.635 0.615
29	Saddle, Fwd Inboard	0.053Inches	+ 0.020 - 0.000	0.073 0.053
30	Saddle, Fwd Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
31	Saddle, Fwd Inboard	1.375Inches	+ 0.020 - 0.000	1.395 1.375
32	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
33	Saddle, Fwd Inboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240
34	Saddle, Fwd Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
35	Saddle, Fwd Inboard	2.000Inches	+ 0.020 - 0.000	2.020 2.000
36	Saddle, Fwd Inboard	0.023Inches	+ 0.020 - 0.000	0.043 0.023

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD	Work Order: 194401
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.998	8.000	7.999	7.999		
F	0.490	0.510		0.498	0.500	0.500	0.500		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.376	0.376	0.375	0.375		
I	0.490	0.510		0.500	0.5005	0.501	0.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.5675	0.568	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.132	0.130	0.130	0.130		
Q	0.115	0.135		0.125	0.125	0.126	0.126		
R	0.240	0.260		0.254	0.254	0.255	0.254		
S	0.115	0.135		0.130	0.130	0.130	0.13		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.240	0.240	0.240	0.240		
W	0.115	0.135		0.132	0.132	0.133	0.133		
X	0.307	0.312		0.311	0.311	0.311	0.311		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.365	0.363	0.363	0.363		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.623	0.624	0.624	0.623		
AC	0.053	0.073		0.065	0.066	0.065	0.065		
AD	0.240	0.260		0.253	0.253	0.253	0.254		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		0.132	0.132	0.130	0.130		
AG	0.240	0.280		0.250	0.250	0.250	0.250		
AH	0.240	0.260		0.252	0.254	0.255	0.254		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: SBL	VMS
Date: 19/05/13	19/5/13

Audited by: [Signature]
Date: 19/05/13

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 194401
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	26	37	48	By	Date
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		0.500	0.500	0.499	0.499		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.375	0.375	0.375	0.375		
I	0.490	0.510		0.500	0.500	0.501	0.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.5675	0.568	0.568	0.563		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.130	0.130	0.131	0.131		
Q	0.115	0.135		0.126	0.126	0.126	0.125		
R	0.240	0.260		0.253	0.254	0.254	0.253		
S	0.115	0.135		0.130	0.130	0.130	0.131		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.2415	0.241	0.244	0.242		
W	0.115	0.135		0.131	0.133	0.133	0.133		
X	0.307	0.312		0.311	0.311	0.311	0.311		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.362	0.365	0.365	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.623	0.622	0.623		
AC	0.053	0.073		0.064	0.063	0.063	0.062		
AD	0.240	0.260		0.256	0.254	0.254	0.253		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.250	0.250	0.250	0.250		
AH	0.240	0.260		0.260	0.2575	0.258	0.254		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.043	0.033	0.033	0.033		
Accept/Reject									

Measured by: VAS	1582
Date: 19/5/10	19/05/14

Audited by: [Signature]	
Date: 19/05/13	

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 194401
Description: Saddle, Fwd Inboard		Part Number: D2572
Inspection Dwg: D2572 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1 9	2 10	3 11	4 12		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.998	7.999	7.998	7.998		
F	0.490	0.510		0.490	0.500	0.498	0.500		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.375	0.375	0.375	0.375		
I	0.490	0.510		0.500	0.499	0.500	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.566	0.567	0.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.500	1.500	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.875	3.874		
P	0.115	0.135		0.133	0.131	0.128	0.128		
Q	0.115	0.135		0.125	0.125	0.125	0.125		
R	0.240	0.260		0.254	0.254	0.254	0.254		
S	0.115	0.135		0.130	0.131	0.130	0.130		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.241	0.240	0.240	0.241		
W	0.115	0.135		0.131	0.133	0.132	0.132		
X	0.307	0.312		0.311	0.311	0.311	0.311		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.366	0.366	0.366	0.367		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.623	0.622	0.622	0.622		
AC	0.053	0.073		0.066	0.066	0.065	0.066		
AD	0.240	0.260		0.253	0.254	0.253	0.253		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.250	0.250	0.250	0.250		
AH	0.240	0.260		0.253	0.253	0.251	0.251		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033					
Accept/Reject									

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>
Date: 19/5/10	Date: 19/05/13

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	